(12) UK Patent Application (19) GB (11) 2072578 A

- (21) Application No 8107330
- (22) Date of filing 9 Mar 1981
- (30) Priority data
- (31) 55/029877U
- (32) 10 Mar 1980
- (33) Japan (JP)
- (43) Application published 7 Oct 1981
- (51) INT CL³ B32B 5/02 // 25/04 25/10 25/14 27/06 27/32
- (52) Domestic classification **B5N** 0502 2504 2510 2514 2706 2732
- (56) Documents cited GB 1391824 GB 1059516
- (58) Field of search B5N
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(54) Sound insulating carpets

(57) A carpet construction having superior sound insulating characteristics useful in the preparation of carpeting for covering the floor of an automobile is disclosed. A carpet has bonded to its rear surface a composition comprising a polyolefin, synthetic rubber, petroleum oil and an inorganic filler. The concentration of inorganic filler is sufficient to provide a composition having a density of at least 1.5 and, in combination with the disclosed polyolefin, synthetic rubber and oil, the flexural modulus of the composition does not exceed 5,000 kg/cm². Carpet constructions incorporating the composition are also disclosed including needle punched, looped-pile, and cut pile.

SPECIFICATION

Sound insulating carpets (P-928)

5 This invention relates to a carpet having superior sound insulating characteristics, particularly for 5 covering the floor of an automobile. This invention particularly relates to sound insulating carpeting which is highly flexible and readily formed by injection molding, extrusion and the tike. More particularly the invention relates to carpet constructions, including a primary cloth with implanted carpet pile and a bonded, dense, sound insulating composition as a backing. 10 Still more particularly this invention relates to methods for preparing sound insulating carpet 10 constructions. BACKGROUND OF THE INVENTION It is known to cover the floor of an automobile with a carpet for shielding or absorbing any 15 noise arising from the bottom of the automobile or its engine or the like to improve comfort 15 when the automobile is running. A known carpet for covering the floor of an automobile is a carpet backed with a polyolefin resin such as polyethylene and an ethylene-vinyl acetate copolymer. The backing material has, however, had only a low surface density and failed to provide satisfactory sound insulation, since it contains no or little filler. In order to improve the 20 sound insulation of such a carpet, it has been proposed to use a backing material containing a 20 large quantity of a high-density filler. The addition of a large quantity of a filler into a polyolefin results, however, in a sharp reduction in its melt-flow characteristics, and renders it difficult to mold in an injection molding machine, an extruder, or the like, since an extremely high torque is required. The backing 25 material thus obtained forms a molded product having a poor appearance, and as it has a high 25 flexural modulus, lacks flexibility and is brittle, and fails to adhere tightly to a carpet when used for backing it. Such material having a high flexural modulus is at a disadvantage in sound insulation, as its coincidence frequency falls within the audible range. Among other polyolefins, an ethylene-vinyl acetate copolymer having a high vinyl acetate 30 content is flammable, has a low melting point and is inferior in heat resistance even if it contains 30 a large quantity of a filler. SUMMARY OF THE INVENTION This invention provides a sound insulating carpet which comprises a carpet having a rear 35 surface, and a composition bonded to the rear surface of the carpet, comprising a polyolefin, 35 synthetic rubber, petroleum oil and an inorganic filler, and having a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm2. The carpet of this invention is superior in sound insulation and flexibility, and possesses the properties required of a carpet. The sound insulating carpet construction of this invention may specifically be constructed in 40 various forms, each comprising the composition described above, bonded to the rear surface of the carpet. In one embodiment a needle punched carpet is obtained by needle punching the carpet fibers on a primary cloth such as jute, synthetic fibers and flat yarn. In another embodiment, looped piles are implanted in the primary cloth and in still another embodiment cut piles are implanted in the primary cloth. In a preferred embodiment the composition includes synthetic rubber from 5 to 400 parts by 45 weight for 100 parts by weight of the polyolefin. In one embodiment, the synthetic rubber is preferably ethylene- α -olefin copolymer, such as ethylene-propylene rubber or ethylene- α -olefin terpolymer, such as ethylene-propylene-ethylidenenorbornene, ethylene-propylene-dicyclopentadiene or ethylene-propylene-1,4-hexadiene. In another preferred embodiment, the synthetic 50 rubber comprises a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin, 50 for example, styrene-butadiene rubber. In another embodiment, the polyolefin component will be an α -olefin homopolymer such as

polypropylene. In another embodiment the polyolefin is an ethylene-propylene block copolymer.

In yet another preferred embodiment the petroleum oil is a paraffinic process oil.

In another embodiment of this invention the composition includes inorganic filler at a concentration which results in a density for the composition of at least 1.5. In a preferred embodiment the inorganic filler is a powder having a particle size not exceeding 150 microns and in yet another preferred embodiment the inorganic filler is barium sulfate.

In another preferred embodiment the composition is extruded and laminated on the rear 60 surface of a carpet, and in a particularly preferred embodiment the composition is at least 0.5mm thick.

DETAILED DESCRIPTION

This invention may specifically be constructed in various forms including:

(1) a sound insulating needle punched carpet comprising the composition having a density

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of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm², and bonded to the rear

synthetic fibers and flat yarn. (2) a sound insulating looped-pile carpet comprising the composition having a density of at least 1.5 and a flexural modulus not exceeding 5,000 5 kg/cm², and bonded to the rear surface of a carpet obtained by implanting looped piles on a primary cloth such as of jute, synthetic fibers and flat yarn; (3) a carpet similar to that described in (2), but having cut piles thereon. For the purpose of this invention, the carpet may be a known carpet, such as one obtained by implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, in synthetic fibers, flat yern, or the like, and a needle punched carpet. The composition for use according to this invention, comprising a polyolefin, synthetic rubber, petroleum oil and an inorganic filler, and having a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm² may contain 5 to 400 parts by weight of the synthetic rubber, petroleum oil for a total of 100. In parts by weight of the polyolefin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an e-delfin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polysthylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethylene-typolylene copolymer, e.g., ethylene-propylene block copolymer, and ethylene-thylacrylate copolymer, and ethylene-ethylacrylate copolymer, and ethylene-ethylacrylate copolymer, and ethylene-ethylacrylate copolymer, and ethylene-ethylacrylate copolymer. An ethylene-ethylacrylate copolymer, and ethylene-ethylacrylate copolymer. An ethylene-propylene-block copolymer and ethylene-ethylacrylate copolymer, and ethylene-ethylacrylate copolymer. An ethylene-propylene-block copolymer and ethylene-propylene-block copolymer and ethylene-propylene-block copolymer. The polyolefin, and alone content of 5 to 40% by weight, a monovinyl		of at least 1.5 and a nextrai modulus not exceeding 5,000 kg/cm², and bonded to the rear	
synthetic fibers and flat yarn; (2) a sound insulating looped-pile carpet comprising the composition having a density of at least 1.5 and a flexural modulus not exceeding 5,000 5 kg/cm², and bonded to the rear surface of a carpet obtained by implanting looped piles on a primary cloth such as of jute, synthetic fibers and flat yarn; (3) a carpet similar to that described in (2), but having cut piles thereon. For the purpose of this invention, the carpet may be a known carpet, such as one obtained by implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, implanting looped primary composition for use according to this invention, comprising a polyolefin, synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm² may contain 6 have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm² polyomer, polybutene-1, poly-4-methylpantene-1, an ethylene-orpolymer, a propylene-butene-1 copolymer, and thylene-butene-1 copolymer, a propylene-butene-1 copolymer, and ethylene-butene-1 copolymer, a propylene-butene-1 copolymer, and ethylene-butene-1 copolymer, and ethylene-ethylacrylate copolymer. Polypropylene and an ethylene-propylene of a monoxinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene-orn entrylene-butene-1 copolymer, and ethylene-propylene-butene-1 copolymer. Entylene-propylene-butene-1 copolymer, and ethylene-propylene-ethyldene-propylene-ethyldene-propylene-propylene-dicycloperhane-diver oppolymer, and ethylene-propylene-dicy		surface of a carpet obtained by needle punching the fibers on a primary cloth such as of jute,	
composition having a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm², and bonded to the rear surface of a carpet obtained by implanting looped piles on a J primary cloth such as of jute, synthetic fibers and flat yam; (3) a carpet similar to that described in (2), but having cut piles thereon. For the purpose of this invention, the carpet may be a known carpet, such as one obtained by implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, yether to composition for cut piles on the front surface of a primary cloth composed mainly of jute, and an endle punched carpet. The composition for use according to this invention, comprising a polyolefin, synthetic rubber, petroleum oil and an inorganic filler, and having a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm² may contrain 5 to 400 parts by weight of the synthetic rubber for 100 parts by weight of the polyolefin, and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an a-celefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethylene-groylene block copolymer, a gentylene-proylene block copolymer, an ethylene-butene-1 copolymer, a proylene-butene-1 copolymer, and proylene copolymer, e.g., ethylene-proylene block copolymer, and ethylene-diversed to endower. Polypropylene and an ethylene-proylene block copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. The synthetic rubber may be an ethylene-acelefin copolymer, a terpolymer or other copolymer comprising ethylene, an a-celefin and one or more dienes, or a copolymer of a monoxinyl aromatic hydrocarbon and a conjugated diclefin. It may have an ethylene-proylene block copolymer and et		synthetic fibers and flat yarn; (2) a sound insulating looped-pile carpet comprising the	
 5 kg/cm², and bonded to the rear surface of a carpet obtained by implanting looped piles on a J primary cloth such as of jute, synthetic fibers and flat yam; (3) a carpet similar to that described in (2), but having cut piles thereon. For the purpose of this invention, the carpet may be a known carpet, such as one obtained by implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, in synthetic fibers, flat yarn, or the like, and a needle punched carpet. The composition for use according to this invention, comprising a polyoletin, synthetic rubber, patroleum cil and an inorganic filler, and having a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm² may contain 5 to 400 parts by weight of the polyoletin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyoletin may be an a-coletin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethylene-orpolymer, a propylene-butene-1 copolymer, and entylene-orpolymer, and entylene-orpolymer orpolyedefins. The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or other copolymer comprising entylene, an α-olefin and one or more dienes, or a copolymer or monoxinyl aromatic hydrocarbon and a conjugated diolefin. It may have an entylene propylene-entyldiene-propylene and an entylene-propylene-divelopenhene-divelopenhene or monoxinyl aromatic hydrocarbon and a conjugated diolefin. It may have an entylene or monoxinyl aromatic hydrocarbon and a conjugated diolefin. It may have an entylene-propylene-entylene-propylene-entylene-propylene-entylene-propy		composition having a density of at least 1.5 and a flexural modulus not exceeding 5.000	
primary cloth such as of jute, synthetic fibers and flat yan; (3) a carpet similar to that described in (2), but having cut piles thereon. For the purpose of this invention, the carpet may be a known carpet, such as one obtained by implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, ynthetic fibers, flat yern, or the like, and a needle punched carpet. The composition for use according to this invention, comprising a polyolefin, synthetic rubber, petroleum cill and an inorganic filler, and having a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm² may contain 5 to 400 parts by weight of the synthetic rubber, or 100 parts by weight of the polyolefin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-olefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethylene-propylene block copolymer, and the ethylene-butene-1 copolymer, a propylene-butene-1 copolymer, an ethylene-butylene plack copolymer, and ethylene-butene-1 copolymer, approylene on an ethylene-vinyl acetate copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. The synthetic rubber may be an ethylene-α-colefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-colefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a monovinyl aromatic hydrocarbon content of 5 to 40% by weight, a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene-copolymer are arthylene-propylene-copylene-copylene-copylene-copylene-copylene-copylene-copylene-copylene-copylene-cop	5	kg/cm² and honded to the rear surface of a carnet obtained by implanting looped piles on a	5
in (2), but having cut piles thereon. For the purpose of this invention, the carpet may be a known carpet, such as one obtained by implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute, implanting looped or cut piles on the composition for use according to this invention, comprising a polyolefin, synthetic rubber, or the composition of the petroleum oil for a total of 100 parts by weight of the polyolefin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-clefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polystylene, polypropylene polybutene-1, poly-4-methylpentene-1, an ethylene-propylene copolymer, a propylene-butene-1 copolymer, and ethylene-with governer, a propylene-butene-1 copolymer, and propylene and an athylene-propylene block copolymer and ethylene-ethylacrylate copolymer. Polypropylene and an athylene-propylene block copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. The synthetic rubber may be an ethylene-exclefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-clefin and one or more dienes, or a copolymer or mixture of two or more polyolefins. The synthetic rubber and a Mooney viscosity (ML ₁₊₁ at 100°C) of 10 to 150. Examples of 30 such rubber include ethylene-propylene-1 viber, an enthylene-propylene-dividene-propylene-ethylidene-propylene-ethylidene-propylene-1 viber, and enthylene-propylene-dividene-propylene-ethylidene-propylene-	·	assess elected and the constitution of the con	J
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10 synthetic fibers, flat yarn, or the like, and a needle punched carpet. The composition for use according to this invention, comprising a polyolefin, synthetic rubber, petroleum oil and an inorganic filler, and having a density of at least 1.5 and a flaxural modulus not exceeding 5,000 kg/cm² may contain 5 to 400 parts by weight of the synthetic rubber for 100 parts by weight of the polyolefin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flaxural modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-olefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethylene-propylene copolymer, e.g., ethylene-propylene block copolymer, and ethylene-1 copolymer, and ethylene-1 copolymer, and ethylene-1-copolymer, and ethylene-1-copolymer, and ethylene-1-copolymer, and ethylene-1-copolymer, and ethylene-1-copolymer and ethylene-propylene-1-dependent ethylene-1-copolymer and ethylene-propylene-1-dependent ethylene-1-copolymer and ethylene-propylene-1-dependent ethylene-propylene-1-dependent ethylene-propylene-1-dependent ethylene-propylene-1-dependent ethylene-1-copolymer and ethylene-propylene-1-dependent ethylene-1-copolymer and ethylene-propylene-1-dependent ethylene-1-copolymer ethylene-1-copolymer ethylene-1-copolymer		implanting looped or cut piles on the front surface of a primary cloth composed mainly of jute	
The composition for use according to this invention, comprising a polyoletin, synthetic rubber, petroleum oil and an inorganic filler, and having a density of at least 1.5 and a flexural modulus not exceeding 5.000 kg/cm² may contain 5 to 400 parts by weight of the synthetic rubber for 100 parts by weight of the polyoletin, 5 to 100 parts of the petroleum oil for a total of 100 parts by weight of the polyoletin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5.000 kg/cm². The polyoletin may be an α-oletin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polyptorpylene, polybutene-1, poly-4-methylephetene-1, an ethylene-propylene copolymer, a propylene-butene-1 polyoletins. The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer of two or more comprising ethylene, an α-olefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a emaphylene content of 5 to 40% by weight, a emaphylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a emaphylene content of 5 to 40% by weight, a diene content of 5 to 40% by weight, a more content of 5 to 80% by weight, a diene content of 5 to 40% by weight, a diene content of 5 to 40% by weight, a more content of 5 to 80% by weight, and a Mooney viscosity (ML ₊₊ , at 100°C) of 10 to 150. Examples of such public rubber include ethylene-propylene rubber, an ethylene-propylene-dicyclopentadiene terpolymer, an ethylene-propylene-thylene-propylene rubber include ethylene-propylene rubber, an ethylene-propylene-d	10	synthetic fibers, flat varn, or the like, and a needle nunched carnet	10
petroleum oil and an inorganic filler, and having a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm² may contain 5 to 400 parts by weight of the synthetic rubber for 100 parts by weight of the polyolefin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-olefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethy-copolymer, e.g., ethylene-propylene block copolymer, and ethylene-butene-1 copolymer or more polyolefins. 25 The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-olefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene-content of 20 to 80% by weight, and a Mooney viscosity (MIL, at 100°C) of 10 to 150. Examples of 30 such rubber include ethylene-propylene-thylidenenorbornene terpolymer, an ethylene-propylene-dividene propylene-dividene prop		The composition for use according to this investion, comprising a polystatic quality of	10
not exceeding 5,000 kg/cm² may contain 5 to 400 parts by weight of the polyolefin, 5 to 100 parts of the petroleum oil for a total of 100 15 parts by weight of the polyolefin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-olefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethylene-copolymer, a propylene-butene-1 copolymer, an ethylene-bropylene block copolymer, and ethylene-ethylacytate copolymer, a propylene-butene-1 copolymer, an ethylene-bropylene block copolymer, and ethylene-ethylacytate copolymer, and ethylene-ethylacytate copolymer, and ethylene-propylene block copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. 25 The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-olefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a diene content of 5 to 40% by weight, and a Mooney viscosity (ML ₁₊₄ at 100°C) of 10 to 150. Examples of 30 such rubber include ethylene-propylene rubber, an ethylene-butene-1 copolymer, an ethylene-propylene-dicyclopentadiene terpolymer, and a styrene-butadiene trandom copolymer, an ethylene-butenel topolymer, an ethylene-propylene-dicyclopentadiene terpolymer, and a styrene-butadiene random copolymer. Ethylene-propylene-rubber is particularly preferable. The petroleum oil may be a hydrocarbon having a boiling point of at least 350°C, for example, a paraffinic, naphthenic or aromatic high-boiling petroleum fraction. A paraffinic fraction is particularly preferable. These oils include process oil. The inorganic filler		The composition for use according to this invention, comprising a polyoletin, synthetic rubber,	
100 parts by weight of the polyolefin, 5 to 100 parts of the petroleum oil for a total of 100 for parts by weight of the polyolefin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-olefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polyptoylene, polybutene-1, poly-4-methylpentene-1, an ethylene-propylene copolymer, a ethylene-propylene block copolymer, an ethylene-butene-1 copolymer, an ethylene-vinyl acetate copolymer, and ethylene-enthylacrylate copolymer. Polypropylene and an ethylene-propylene block copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. 25 The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-olefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a monovinyl aromatic hydrocarbon content of 20 to 80% by weight, and a Mooney viscosity (ML _{1-x} at 100°C) of 10 to 150. Examples of 30 such rubber include ethylene-propylene rubber, an ethylene-propylene-dicyclopentadiene terpolymer, an ethylene-propylene-dicyclopentadiene terpolymer, and sylvene-butadiene random copolymer. Ethylene-propylene-dicyclopentadiene block copolymer, and a styrene-butadiene random copolymer. Ethylene-propylene rubber is particularly preferable. The petroleum oil may be a hydrocarbon having a boiling point of at least 350°C, for 35 example, a paraffinic, naphthenic or aromatic high-boiling petroleum fraction. A paraffinic fraction is particularly preferable. These oils include process oil. The inorganic filler may, for example, be a metal such as iron, zinc, nickel, chromium, lead, copper, 40 molybdenum and mangane		petroleum oil and an inorganic tiller, and having a density of at least 1.5 and a flexural modulus	
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 15 parts by weight of the polyolefin and the synthetic rubber, and that quantity of the inorganic filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-olefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethylene-propylene copolymer, a propylene-butene-1 copolymer, a propylene-butene-1 copolymer, an ethylene-ethylacyteta copolymer, and ethylene-ethylacyteta copolymer, a propylene-butene-1 copolymer, an ethylene-bropylene block copolymer and ethylene-ethylacyteta copolymer, a propylene-butene-1 copolymer, an ethylene-bropylene block copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. 25 The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-olefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene- content of 50 to 40% by weight, a diene content of 5 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, a diene content of 50 to 40% by weight, and and 40 to 40% by weight, and 60 to 40% by weight, and 60 to 40% by weight, and 60 to 4		100 parts by weight of the polyolefin, 5 to 100 parts of the petroleum oil for a total of 100	
filler which is required to enable the composition to have a density of at least 1.5 and a flexural modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-olefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylane, polypropylane, polybutene-1, poly-4-methylanene-1, an ethylene-propylene copolymer, e.g., ethylene-propylene block copolymer, an ethylene-butene-1 copolymer, an ethylene-propylene block copolymer, an ethylene-tutene-1 copolymer, an ethylene-propylene block copolymer, and ethylene-ethylacrylate copolymer. Polypropylene and an ethylene-propylene block copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. 25 The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-olefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a monovinyl aromatic hydrocarbon content of 20 to 80% by weight, and a Mooney viscosity (ML ₁₋₄ at 100°C) of 10 to 150. Examples of 30 such rubber include ethylene-propylene-rubber, an ethylene-butene-1 copolymer, an ethylene-propylene-ethyldenenorborene terpolymer, an ethylene-propylene-ethyldenenorborene terpolymer, an ethylene-propylene rubber is particularly preferable. The petroleum oil may be a hydrocarbon having a boiling point of at least 350°C, 635 example, a paraffinic, naphthenic or aromatic high-boiling petroleum fraction. A paraffinic fraction is particularly preferable. These oils include process oil. The inorganic filler may be selected from among metals, metal compounds, silicates and silicate minerals, and those which are chemically stable in ordinary use. More specifically, the inorganic filler may, for example, be a metal such as iron, zinc, nickel, chromium, lead, copper, 40 molybdenum and manganesse, an oxide, carbonate or sulfate of a	15	parts by weight of the polyplefin and the synthetic rubber, and that quantity of the inorganic	15
modulus not exceeding 5,000 kg/cm². The polyolefin may be an α-clefin homopolymer, or a crystalline copolymer consisting mainly thereof, such as polyethylene, polypropylene, polybutene-1, poly-4-methylpentene-1, an ethylene-propylene copolymer, e.g., ethylene-propylene block copolymer, an ethylene-butene-1 copolymer, a propylene-butene-1 copolymer, a propylene-butene-1 copolymer, a propylene-butene-1 copolymer, and ethylene-ethylacrylate copolymer, and ethylene-oropylene block copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. 25 The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, and a Mooney viscosity (Ml ₁₋₁₄ at 100°C) of 10 to 150. Examples of 30 such rubber include ethylene-propylene-rubber, an ethylene-butene-1 copolymer, an ethylene-propylene-1.4-hexadiene terpolymer, an ethylene-propylene-1.4-hexadiene terpolymer, a styrene-butadiene block copolymer, and a styrene-butadiene random copolymer. Ethylene-propylene-dicyclopentadiene terpolymer, and a styrene-butadiene random copolymer. Ethylene-propylene urbber is particularly preferable. The petroleum oil may be a hydrocarbon having a boiling point of at least 350°C, for 35 example, a partificinic, naphthenic or aromatic high-boiling petroleum fraction. A paraffinic fraction is particularly preferable from any stable in ordinary use. More specifically, the inorganic filler may be selected from among stable in ordinary use. More specifically, the inorganic filler may be selected from among stable in ordinary use. More specificy the		filler which is required to enable the composition to base a density of the live of Early flower	10
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copolymer, a propylene-butene-1 copolymer, an ethylene-propylene block copolymer are particularly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more polyolefins. 25 The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-olefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a monovinyl aromatic hydrocarbon content of 20 to 80% by weight, and a Mooney viscosity (ML ₁₋₁ at 100°C) of 10 to 150. Examples of 30 such rubber include ethylene-propylene rubber, an ethylene-butene-1 copolymer, an ethylene-propylene-ethylidenenorbornene terpolymer, an ethylene-propylene-dicyclopentadiene terpolymer, an ethylene-propylene-1,4-haxadiene terpolymer, a styrene-butadiene block copolymer, and a styrene-butadiene random copolymer. Ethylene-propylene-tubber is particularly preferable. The petroleum oil may be a hydrocarbon having a boiling point of at least 350°C, for sample, a paraffinic, naphthenic or aromatic high-boiling petroleum fraction. A paraffinic fraction is particularly preferable. These oils include process oil. The inorganic filler may be selected from among metals, metal compounds, silicates and silicate minerals, and those which are chemically stable in ordinary use. More specifically, the inorganic filler may, for example, be a metal such as iron, zinc, nickel, chromium, lead, copper, aluminum, titanium, calcium or magnesium, or talc, clay, silica, mica, asbestos, silicic anhydride, or the like. It is particularly preferable to use aclicium carbonate, barium sulfate, lead, iron, zinc, or a compound of any such metal. Barium sulfate is most preferable from the standpoint of thermal stability. It is possible to use either only a single kind of filler, or a mixture of two or more. The filler may be composed of a powder, fibers, foils, or the like, but it is de	20	lene-propylene conglymer, e.g., ethylene-propylene block conglymer, en ethylene-butene, 1	20
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polyolefins. The synthetic rubber may be an ethylene-α-olefin copolymer, a terpolymer or other copolymer comprising ethylene, an α-olefin and one or more dienes, or a copolymer of a monovinyl aromatic hydrocarbon and a conjugated diolefin. It may have an ethylene content of 20 to 80% by weight, a diene content of 5 to 40% by weight, a monovinyl aromatic hydrocarbon content of 20 to 80% by weight, and a Mooney viscosity (ML ₁₊₄ at 100°C) of 10 to 150. Examples of 30 such rubber include ethylene-propylene rubber, an ethylene-butene-1 copolymer, an ethylene-propylene-ethyldenenorbornene terpolymer, an ethylene-butene-1 copolymer, an ethylene-propylene-ethyldenenorbornene terpolymer, an ethylene-propylene-dicyclopentadiene terpolymer, and a styrene-butadiene random copolymer. Ethylene-propylene rubber is particularly preferable. The petroleum oil may be a hydrocarbon having a boiling point of at least 350°C, for 35 example, a paraffinic, naphthenic or aromatic high-boiling petroleum fraction. A paraffinic fraction is particularly preferable. These oils include process oil. The inorganic filler may be selected from among metals, metal compounds, silicates and silicate minerals, and those which are chemically stable in ordinary use. More specifically, the inorganic filler may, for example, be a metal such as iron, zinc, nickel, chromium, lead, copper, molybdenum and manganese, an oxide, carbonate or sulfate of any such metal, or barium, aluminum, titanium, calcium or magnesium, or talc, clay, silica, mica, asbestos, silicic anhydride, or the like. It is particularly preferable to use calcium carbonate, barium sulfate, lead, iron, zinc, or a compound of any such metal. Barium sulfate is most preferable from the standpoint of thermal stability. It is possible to use either only a single kind of filler, or a mixture 45 of two or more. The filler may be composed of a powder, fibers, foils, or the like, nor the single proposed of a powder, fibers, foils, or the like, nor the single proposed of a powder, fibers, foils,		larly preferable. It is possible to use either only one such polyolefin, or a mixture of two or more	
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CONTINUOUSIV through a nozzle on an extruder for lamination on the rear surface of a carnet and		It is however industrially appropriate to make the palement and the approach of an adnesive.	
apply a pressure thereto by a roller. The amount of the composition to be laminated depends on		continuously through a possible on the continuously through a possible of the continuously through the co	
apply a pressure thereto by a roller. The amount of the composition to be laminated depends on	p c	continuously unough a nozzie on an extruder for lamination on the rear surface of a carpet, and	•
•	00	apply a pressure thereto by a roller. The amount of the composition to be laminated depends on	65
		·	

5	effect of sound in 0.5 mm, and particle density of at least antistatic agent, surface active ag As hereinabove insulation and flexelicles and built	nsulat rticula t 2 kg an an ent, c e dese exibilit dings will n	ion, it orly at l g/cm²) tioxida or the l cribed, ty, and ow be	is desi least 0). If red nt, a li ike into this in is not descrif	rable to I .8 mm (i quired, it ubricant, o the con evention i only sui bed with	laminate the co i.e., to the exterior possible to an ultraviolet inposition. provides a carp table for use we reference to ex	s a greater thickness produces a high composition in a thickness of at least ent that the carpet may have a surface incorporate a coloring agent, an liquid absorber, a heat stabilizer, a pet which is superior in sound with automobiles, but also with other examples which are not intended to be	5			
15	of polypropylene (PP) having a MI of 22 at 230°C according to ASTM D-1238, an ethylene- vinyl acetate copolymer (EVA) having a MI of 20 at 190°C, ethylene-propylene rubber having an										
20	ethylene content of 70% by weight and a Mooney viscosity of 70, barium sulfate (BaSO ₄) having an average particle size of 7 μ and a paraffinic process oil (Kyodo Sekiyu's R-1000) into a Banbury mixer, and kneading them for 10 minutes at a temperature of 190°C to 200°C, followed by cooling and crushing. Each of the compositions thus obtained was tested for density according to JIS K-6758, for flexural modulus according to ASTM D-790, for melting point by										
25	a DSC differential calorimeter, and for flexibility. The results are shown in TABLE 1. The flexibility of each composition was evaluated by a bend and feel test on a sheet thereof having a thickness of 3 mm. In TABLE 1, a double circle means 'very soft'; a single circle, 'soft'; and an x, 'hard'.										
30	(2) Manufacture of sound insulating carpets. Each of the compositions obtained from Run Nos. 1 and 2 was continuously extruded through an extrusion molding machine, and laminated in a thickness of 2.5 mm on the rear surface of a needle punched carpet obtained by needle punching polypropylene fibers (15 d) (800 g/m²) and backing with a latex, followed by compression, whereby a carpet was formed.										
35	automobile carpe and a density of this invention. The	ets ob 0.91 ne car ne no	tained 2 on ca pets w	by ext arpet be ere me	rusion la bases of t ounted fo	minating low-d he same type or or covering the	escribed were compared with known density polyethylene having a MI of 5 as used for preparing the carpets of a floor of an automobile, and compared an it was running. The results are	35			
40	TABLE 1	Prop	erties ding to		npositions ts	s for		40			
AE	Run No.	PP	EVA	EPR	BaSO ₄	Process oil		45			
45	1 2 2 (Company)	10 15	_	10 10	65 65	15 10					
FΩ	3 (Comparative Example 4 (Comparative	35		—	65	_	•	50			
, 90	Example Comparative		35	-	65	_		- •			
	Example			_							

TABLE 1	(Continued)
	Properties of compositions for
	bonding to carpets

5		-	Flexural	Molting		Carpet eva	Noise*	4	5	5
10	Run No.	Density (g/cm³)	modulus (Kg/cm²)	point	Flexibility	Surface density (Kg/cm²)	inside automobile (dB)	•	,	
,,,	1 2 3 (Comparative	1.86 1.87	2,000 2,500	151.8 153.2	0	5.45 5.48	65 65		10	,
15	Example) 4 (Comparative	1.88	22,000	161.5	×		_		15	;
	Example Comparative	1.89	5,000	65.0	0					
	Example					3.08	74			
20	(Note)* The nois chassis t	e was me testing ap	asured wit paratus.	h an auto	mobile runn	ing at 100	km/hr. in a		20	
25	Example 2 Compositions a 1, except for the which will hereun	use of the	polyolefin	. svntheti	ic rubber, ne	etroleum oil	e procedures of i , inorganic filler a	Example and carpet	25	
30	(1) Polyolefin (A) Ethylene-p MI of 9 at 230°C	ropylene	block copa	lymer hav	ving an ethy	lene conten	t of 7% by weig	ht and a	30	
35	(B ₂) Ethylene- viscosity of 70; or	utadiene l of 24; propylene r propylene-	rubber ha	ving an e	thylene cont ne terpolym	ent of 70% er having a	f 40% by weight by weight and a propylene conter Mooney viscosity	Mooney	35	
40	(3) Petroleum oil (C ₁) Paraffinic (C ₂) Napthenic	l process o	il; or						40	
45	(4) Inorganic fille (D ₁) Zinc oxide I (D ₂) Calcium car (D ₃) Talc having (D ₄) Iron powde	having an rbonate ha an avera r having a	aving an av ge particle In average	verage pa size of 1: particle s	rticle size of 2 μ; size of 90 μ:	2 μ;			45	ŗ
50	(D _s) Iron oxide to (5) Carpet Needle punched				·	g/m²).			50	š,

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TABLE 2 Properties of compositions for bonding to carpets

5 Run No	Polyolefin . (parts)	Synthetic rubber (parts)	Petroleum oil (parts)	Inorganic filler (parts)
5	A	B,	C ₂	D ₁
6	(30) A	(10) B ₁	(10) C ₂	(100) D ₁
10 7	(20) A	(10) B ₂	(20) C ₁	(100) D ₂
8	(10) A	(5) B ₂	(10) C,	(75) D ₃
15 9	(10) A	(5) B ₃	(10)	(75) D₄
	(20)	(10)	(10)	(120)
10	A (20)	B ₃ (10)	(10)	D₅ (120)
Compara	ative —			

TABLE 2 (Continued) Properties of compositions of bonding to carpets

25	Run No.	Density (g/cm³)	Flexural modulus (Kg/cm²)		Flexibility	Carpet eva Surface density (Kg/cm²)	aluation Noise inside an automobile (dB)	25
30	5	2.03	2,000	154.1	Q	5.88	64	30
	6	2.02	1,500	152.9	0	5.85	64	
	7	1.79	3,800	156.3	0	5.28	65	
	8	1.68	4,500	158.4	Ŏ	5.00	66	
	9	2.66	2,500	155.5	Ŏ	7.45	62	
35	10	2.33	2.200	154.8	Ŏ	6.62	63	35
	Comparative	_			<u>~</u>	3.08	74	

Reference Example

40 TABLE 3 shows the sound insulating characteristics measured on the carpets prepared in Runs Nos. 2 and 9 and the Comparative Example shown in TABLE 1. For determination of the sound insulating effect of each carpet, it was mounted on a speaker box in which the vibration generated by a transmitter was converted to a noise by a loud speaker. The noise arising from the loud speaker was received by a microphone in a noise meter positioned opposite to the 45 speaker, and the sound pressure was measured at various frequencies.

TABLE 3

50	Run No.	Filler	Surface density (Kg/cm²)
	2	BaSO₄ Iron	5.48
55	_	powder	7.45
	comparative Example	_	3.08

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5	Run No.	Transmission loss (dB) [Needle punched carpet having a 25 mm thick sheet laminated thereon] Frequency for measurement (Hz)						
40	2 9	100 17 15	200 14 12	400800 16 25 18 27	1,000 25 28	2,000 33 36	4,000 38 41	
10	comparative Example	<5	<5	10 15	16	23	29	10

CLAIMS

A sound insulating carpet construction comprising a carpet having a rear surface, and a composition bonded to said rear surface, said composition comprising (A) polyolefin, (B) ethylene-α-olefin or monovinyl aromatic hydrocarbon conjugated diolefin copolymer rubber, (C) petroleum oil and (D) inorganic filler.

2. A carpet construction according to claim 1 wherein said carpet is selected from needle 20 punched carpet, looped pile carpet and cut pile carpet.

- 3. A carpet construction according to claim 1 or 2 wherein said rear surface is comprised of a primary cloth selected from jute, synthetic fibers and flat yarn.
- 4. A carpet construction according to claims 1-3 wherein said composition has a density of at least 1.5.
- 5. A carpet construction according to claims 1-4 wherein said composition has a flexural modulus not exceeding 5,000 kg/cm².
 - 6. A carpet construction according to claims 1-5 wherein said polyolefin is polypropylene or ethylene-propylene block copolymer.
- A carpet construction according to claims 1-6 wherein said ethylene-α-olefin rubber is
 selected from the group consisting of ethylene-propylene copolymer, ethylene-propylene-ethylidenenorbornene terpolymer, ethylene-propylene-dicyclopentadiene terpolymer and ethylene-propylene-1,4-hexadiene terpolymer.
 - 8. A carpet construction according to claims 1-7 wherein said petroleum oil is selected from paraffinic, naphthenic and aromatic process oils.
- 9. A carpet construction according to claims 1–8, wherein said inorganic filler is selected from the group consisting of calcium carbonate, barium sulfate, and the oxide carbonate and sulfate of lead, iron and zinc.
 - 10. A carpet construction according to claim 9 wherein said inorganic filler is a powder having a particle size not exceeding 150 microns.
- 11. A carpet construction according to claim 10 wherein the ratio of the volume of said inorganic filler to the sum of the volumes of components (A), (B) and (C) is less than or equal to two.
 - 12. A carpet construction according to claims 1-11 wherein the thickness of said composition bonded to said rear surface is at least 0.5 mm.
- 45 13. A method for producing a sound insulating carpet construction according to claims 1–12 comprising provided a primary cloth having a rear surface and a front surface, preparing a sound insulating composition comprising (A) polyolefin, (B) ethylene-α-olefin or monovinyl aromatic hydrocarbon-conjugated diolefin copolymer rubber, (C) petroleum oil and (D) inorganic filler, implanting carpet fibers in said front surface and bonding said composition to said rear surface.

14. A method according to claim 13 wherein said composition is melted by the application of heat, extruded and laminated to said rear surface by the application of pressure.

- 15. A method according to claim 13 or 14 wherein the thickness of said composition on said rear surface is at least 0.5 mm.
- 55 16. A method according to claims 13–15 including molding said carpet construction into a 55 desired shape by the application of heat and pressure thereto.